

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018680**Date Inspected:** 13-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of various weld joints located inside PCMK OBG 11BW/11CW, holdback welds, bottom plate T-ribs to bottom plate. Welder was identified as 040378. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as verbally identified by QC1. QC1 informed this QA Inspector that these repairs were the result of visual testing (VT) and he was not recording each individual weld number.

SMAW welding of weld joints SEG072A-045 and SEG074A-014 located outside PCMK OBG 11BE/11CE, holdback welds on both sides of the transverse joint, side plate to bottom plate, south (bikepath) side. Welder was identified as 053871. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbally identified by QA1.

SMAW welding of weld joints OBE11A-006 located outside PCMK OBG 11DE/11EE, edge plate to edge plate, north (crossbeam) side. Welder was identified as 040484. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbally identified by QC1.

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## WELDING INSPECTION REPORT

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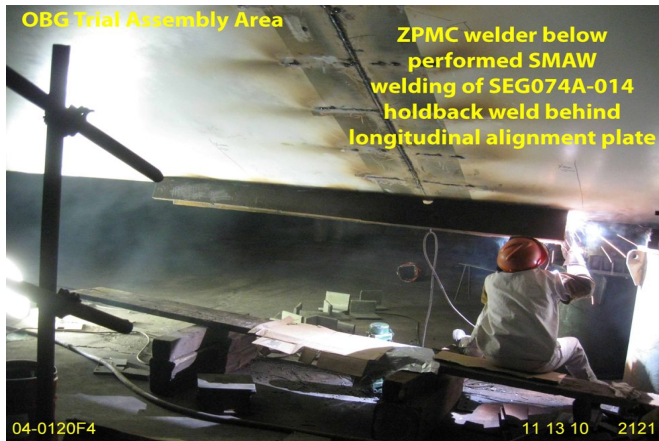
### Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All four towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. The ZPMC 1600 ton floating crane was moored near the end of the Heavy Dock and working on a project other than this contract.

OBG segment 10E was positioned on the deck of the ship moored to the end of the Heavy Dock. OBG segment 10W was positioned on top of OBG segment 10E. All four towers, lift 3 were positioned horizontally on the deck of the ship. OBG CB 13 and CB14 were positioned on the deck of the ship. ZPMC personnel were loading various bridge parts onto the ship. No welding work was observed being performed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert
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QA Reviewer
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